

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021963**Date Inspected:** 26-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW repair welding of weld joint DP3174-001-019 located on PCMK OBG 14W. Welder was identified as 066038. QC was identified as ZPMC CWI Liu Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair as displayed on ZPMC Weld Repair Report B-WR20313 presented to this QA Inspector and verbally identified by QCA1. See photo below of ZPMC Weld Repair Report B-WR20313 as presented to this QA Inspector.

SMAW welding of weld joint DP3172-001-023 located on PCMK OBG 14W. Welder was identified as 067588. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joint SEG3020U-589 located on PCMK OBG 14W. Welder was identified as 067949. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2233-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3013M-001 located on PCMK OBG 13AW. Welders were identified as 066421, 667826. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

SMAW welding of weld joint SEG3015B-001 located on PCMK OBG 13CW. Welder was identified as 066443. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2213-TC-U4b-FCM-1 as verbally identified by QCA1.

SMAW repair welding of weld joint DP3163-001-028 located on PCMK OBG 14E. Welder was identified as 215553. QC was identified as ZPMC CWI Geng Wei (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Ku (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20222 presented to this QA Inspector and verbally identified by QCA2. See photo below of the repair as welded and cleaned.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Bay 14

ZPMC		焊缝返修报告		版本 Rev No.	
Welding Repair Report				0	
项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	DP3174	报告编号 Report No.	B-WR20313
合同号 Contract No.	04-0120F4	部件名称 Items Name	14W DECK PLATE SPLICE	NDT报告编号 Report No of NDT	B787-UT-20312
项目编号 Project No.	ZP06-787				

焊缝缺陷描述: (普通可探测发现的缺陷长度小于最大允许长度)
(Description of welding discontinuity): Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

焊缝编号为: DP3174-001-018 DP3174-001-394 DP3174-001-019 DP3174-001-020 DP3174-001-021 DP3174-001-393

检验员 (Inspector): Tang Xingshan (Date): 2011.02.24

04-0120F4 B-WR20313 as presented to this QA Inspector 02 26 11 2010



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer